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D4146-1**Job Sheet 193486****Part No:** D4146-1**Job Qty:** 20 pcs**Part Name:** Fitting**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/15/19**Job Tracking No:****Due Date:** 4/30/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP REV:A NEW ISSUE 10-10-05 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	20 pcs	4/30/19	4/30/19	0.00	8.00	Doosan - 1		
120	QC 8	20 pcs	4/30/19	4/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Packaging 3-1 - Stock - B4B	20 pcs	4/30/19	4/30/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S178018**Part:** D4146-1**Job No:** 193486**Serial No/Batch:** S178018**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 05/04/19

MAY 06 2019				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA 20 pcs 4/30/19 0.00 0.00				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 MAY 06 2019
				QC 21 - SA - 53	3-53

Part Op 100 - (Doosan Lathe)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	3.3320 ft (.1666 ea)	100-Doosan - 1	5 156 (21)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R1.000	3	42	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.290Inches + 0.006 - 0.001	0.296 0.289	Diameter	.292
2	Fitting	0.810Inches ± 0.010	0.820 0.800		.810
3	Fitting	0.550Inches ± 0.010	0.560 0.540	Diameter	.554
4	Fitting	0.470Inches ± 0.010	0.480 0.460	Diameter	.468
5	Fitting	0.330Inches ± 0.010	0.340 0.320	Diameter	.340
6	Fitting	0.063Inches ± 0.010	0.073 0.053		.063
7	Fitting	1.790Inches ± 0.030	1.820 1.760		1.790
8	Fitting	1.700Inches ± 0.030	1.730 1.670		1.710
9	Fitting	1.590Inches ± 0.030	1.620 1.560		1.593
10	Fitting	1.190Inches ± 0.030	1.220 1.160		1.192
11	Fitting	0.840Inches ± 0.030	0.870 0.810		.813
12	Fitting	0.810Inches ± 0.030	0.840 0.780		.814
13	Fitting	0.500Inches ± 0.030	0.530 0.470		.499
14	Fitting	0.539Inches ± 0.010	0.549 0.529	Diameter	.533

Plex 4/15/19 4:05 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					